

**Amendments to the Claims:**

This listing of claims will replace all prior versions, and listings, of claims in the application:

**Listing of Claims:**

1. (previously presented) A cast iron alloy for a cast iron product characterized by high thermal stability, the alloy consisting essentially of, as nonferrous constituents, positive additions of C, Si, Mo, Al, Ni, Zr, wherein C is present in an amount of 2.5 to 2.8% by weight, the Si content is 4.7 to 5.2% by weight, the Mo content is 0.5 to 0.9% by weight, the Al content is 0.5 to 0.9% by weight, the Ni content is 0.1 to 1.0% by weight, and wherein the Zr content is 0.1 to 0.4% by weight, wherein graphite in the as cast iron alloy comprises spheroidal graphite.

2-9. (canceled).

10. (previously presented) The cast iron alloy as claimed in claim 1, including Mg and S each up to .05 wt.% max, and balance essentially Fe.

11. (original) The cast iron alloy as claimed in claim 1, wherein the cast iron product comes into contact with exhaust gas from an internal combustion engine.

12. (previously presented) The cast iron alloy as claimed in

claim 1, wherein the cast iron product is an exhaust manifold for receiving exhaust gases from an internal combustion engine.

13. (currently amended) A process for producing the cast iron alloy as claimed in ~~claim 7~~ any one of claims 1, 12 and 15, wherein the Al and Zr are added as an Al-Zr prealloy immediately before the alloy melt is cast.

14. (original) A process for producing the cast iron alloy as set forth in claim 13, wherein the temperature of the alloy melt is over 1460°C immediately prior to casting.

15. (currently amended) In combination, an internal combustion engine and a cast iron product comprising an exhaust manifold for the internal combination engine, the cast ~~into product~~ exhaust manifold being contacted with exhaust gases from the internal combustion engine, the cast ~~iron-product~~ exhaust manifold comprises a cast iron alloy consisting essentially of, as nonferrous constituents, positive additions of C, Si, Mo, Al, Ni, Zr, wherein C is present in an amount of 2.5 to 2.8% by weight, the Si content is 4.7 to 5.2% by weight, the Mo content is 0.5 to 0.9% by weight, the Al content is 0.5 to 0.9% by weight, the Ni content is 0.1 to 1.0% by weight, and wherein the Zr content is 0.1 to 0.4% by weight, wherein graphite in the as cast iron alloy comprises spheroidal graphite, wherein the exhaust manifold is exposed to temperatures of greater than 900°C.

16. (previously presented) A cast iron alloy according to claim 1, wherein S is less than .01.

17. (currently amended) A cast iron alloy according to claim ~~±~~  
15, wherein S is less than ~~±15~~ .01.